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11953

647.1301
Job Sheet 188540

Part No: 647.1301

Job Qty: 1 pcs

Part Name: EC145 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/10/19

Job Tracking No:

Due Date: 2/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 647.1301 REV E IPP REV:A 12.10.05 NEW ISSUE DD VERF:JLM IPP REV B: 13.07.16 AS PER REV B JLM
VERIFIED BY:DD IPP REV:C 14.05.05 AS PER DWG REV C1 DD VERF:JLM IPP REV:D 15.07.08 AS PER
REV D DD VERIFIED BY:JLM IPP REV:E 18.05.02 AS PER REV.E JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	2/4/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
QC / QA Coordinator Approval 									

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐ _____					
Misidentified ☐	Past Due ☐						

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	QC 4	1 pcs	2/4/19	0.00 0.00	QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
125	DC - 1 - B4B	1 pcs	2/4/19	0.00 0.00	DC - 1 - B4B	DAS 46 FEB 22 2019 9-89
					DC - 2 - B4B	
130	Packaging 3-1 - Stock - B4B	1 pcs	2/4/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS 46 FEB 22 2019 9-89
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	1 pcs	2/4/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	DAS 21 FEB 22 2019 9-89
Part Op 110 - (Pick Kit) Descriptions: 120 - (QC4- 100% Inspect kits for completeness) 125 - (Document Control) Photocopy bluefile & type labels per PPP 647.1301 130 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP 647.1301 Location:FG109 EXPIRY DATE OF: RTV Loctite 598: _____ MAGNOBOND 6398 PART 1: _____ MAGNOBOND 6398 PART 2: _____ SEALANT PR-1425: _____ ***INDICATE ON BOX EXPIRY DATE OF RTV, MAGNOBOND PART1, MAGNOBOND PART2 AND SEALANT PR-1425 ***						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER :					
☐ Misidentified	☐ Past Due						

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5134403
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5139402
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5122215
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5120467
601.2375	Washer 90965A160	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5162289
601.2999	Screw	3 pcs (3 ea)	110-Packaging 1 - Pick Kit	5049458
601.3004	26S8-11 Camloc Stud	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5084900
601.3005	2600-L-W Camloc Retainer	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5158642
601.3006	Camloc Receptacle - 26R 16-1	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5084902
601.3011	P-Seal	3 pcs (3 ea)	110-Packaging 1 - Pick Kit	5006166
647.0112	Strut Bracket	8 pcs (8 ea)	110-Packaging 1 - Pick Kit	5133711
647.1401	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	51351200
647.1402	Lower Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5130528
647.1601	Wiper Deflector Aft	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5122234
647.1602	Doubler Assembly	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5097988
647.1610	Wiper Deflector Fwd	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5049889
647.1701	Skid Deflector Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5148203
647.1810	Nose Door Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	51130388
647.1811	Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	51130388-23
647.1812	Shim	13 pcs (13 ea)	110-Packaging 1 - Pick Kit	51130388-14
647.1813	Angle	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	512094
647.1814	Gusset LH	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5026912
647.1815	Gusset RH	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	51130388-26
647.1816	Support LH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5040326
647.1817	Support RH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5125082
647.1818	Nose Door Spacer	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	51130388-17
647.1910	Clip	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5192226
647.1911	Bracket RH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5192222
647.1912	Bracket LH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5192228
647.1913	Tee	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5100035
647.1914	Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5101859
647.1915	Support Angle	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5100793
647.2010	Upper Strut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5106783
647.2011	Lower Strut	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5120021
647.2110	Lower Rail	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5125082
647.2111	Upper Rail	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5123254
647.2201	Cross Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	51162949
647.2510	Sleeve	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5125082-55
647.2511	Nut	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5154697
647.3201	Grounding Cable Assembly	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5084918
AN3-11A	Bolt	16 Ea (16 ea)	110-Packaging 1 - Pick Kit	5129968
AN3-4A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5112901
AN3C10A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5130324
AN4CH6A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	51126176
CCR264SS-3-03	Cherry Rivet	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5099729
CCR264SS3-04	Rivet	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5120512
CCR274SS-3-03	Rivet	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5123785-0
CR3213-4-2	Cherry Rivet	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5116951
CR3213-4-3	Rivet, Cherry	22 Ea (22 ea)	110-Packaging 1 - Pick Kit	5089319
CR3213-4-4	Rivet, Cherry	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5104324
CR3213-4-5	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5118040-1
CR3213-4-6	Rivet	11 Ea (11 ea)	110-Packaging 1 - Pick Kit	5019369
CR3213-4-7	Rivet	16 Ea (16 ea)	110-Packaging 1 - Pick Kit	5123785
CR3213-4-8	Rivet	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5067267
CR3213-6-6	Rivet (601.2995)	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5123785-45
MS21042-08	Use Ms21042L08	9 Ea (9 ea)	110-Packaging 1 - Pick Kit	5080644
MS21042-3	Nut	45 Ea (45 ea)	110-Packaging 1 - Pick Kit	5132364
MS21042L4	Nut	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5133333

Exp 5/19
Exp 10/20

FM130388-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
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Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :			
Misidentified ☐	☐	Past Due	☐				

MS21047-3	Nut Plate	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5103.943
MS21266-2N	Grommet	1.1000 Ea (1.1 ea)	110-Packaging 1 - Pick Kit	5129988
MS24694-C52	Screw	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5069269
MS27039-08-07	Screw	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5084885
MS27039-08-10	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5128799-50
MS27039-08-13	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5123937
MS27039-1-07	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5111086
MS27039-1-10	Screw	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5124663
MS27039-1-14	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5120449-40
MS27039-1-15	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5112435
MS27039-1-17	Screw (601.1954)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5127831-4
MS27039-1-20	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5094554
MS27039C1-06	Screw (601.2459)	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	5123525-30
NAS1149F0332P	Washer	102 Ea (102 ea)	110-Packaging 1 - Pick Kit	5134693
NAS1149F0432P	Washer	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5131202-2
NAS1149FN832P	Washer	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	5136368
NAS1834C3-300	Insert	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5153859
NAS6604-66	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5122089x2 514387x2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0990	1	22	0
	600.0991	1	22	0
	600.1012	1	23	0
	601.2045	1	27	0
	601.2375	3	70	0
	601.2999	3	24	0
	601.3004	2	10	0
	601.3005	2	27	0
	601.3006	2	2	0
	601.3011	3	128	0
	647.0112	8	62	0
	647.1401	1	0	0
	647.1402	1	1	0
	647.1601	1	17	0
	647.1602	1	5	0
	647.1610	1	42	0
	647.1701	2	0	0
	647.1810	1	41	0
	647.1811	2	60	0
	647.1812	13	90	0
	647.1813	2	32	0
	647.1814	1	44	0
	647.1815	1	32	0
	647.1816	1	2	0
	647.1817	1	24	0
	647.1818	1	54	0
	647.1910	4	27	0
	647.1911	1	10	0
	647.1912	1	3	0
	647.1913	1	43	0
	647.1914	1	39	0
	647.1915	1	38	0
	647.2010	2	29	0
	647.2011	2	4	0
	647.2110	1	9	0
	647.2111	1	4	0
	647.2201	1	6	0
	647.2510	4	39	0
	647.2511	4	8	0
	647.3201	1	5	0
	AN3-11A	16	131	0
	AN3-4A	2	177	0
	AN3C10A	2	50	0
	AN4CH6A	1	59	0
	CCR264SS-3-03	12	403	0
	CCR264SS3-04	12	87	0
	CCR274SS-3-03	4	207	0
	CR3213-4-2	2	91	0

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER :																																																																							

CR3213-4-3	22	90	0
CR3213-4-4	4	162	0
CR3213-4-5	8	165	0
CR3213-4-6	11	215	0
CR3213-4-7	16	134	0
CR3213-4-8	12	73	0
CR3213-6-6	8	232	0
MS21042-08	9	1	0
MS21042-3	45	124	0
MS21042L4	4	1,988	0
MS21047-3	12	279	0
MS21266-2N	1	15	0
MS24694-C52	10	112	0
MS27039-08-07	1	254	0
MS27039-08-10	4	189	0
MS27039-08-13	4	497	0
MS27039-1-07	3	174	0
MS27039-1-10	6	167	0
MS27039-1-14	4	52	0
MS27039-1-15	4	285	0
MS27039-1-17	2	54	0
MS27039-1-20	4	114	0
MS27039C1-06	18	72	0
NAS1149F0332P	102	2,468	0
NAS1149F0432P	8	916	0
NAS1149FN832P	18	3,391	0
NAS1834C3-300	2	127	0
NAS6604-66	4	2	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

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	2	2							89	647.1703	T2 SKID DEFLECTOR ASSY		
	8	8							88	601.3812	LOCK TAB	LN9023A8-1.4544.9	
				2	2				87	647.1702	SKID DEFLECTOR ASSY		
	1	1		1	1				86	647.2113	LOWER RAIL (U CHANNEL KIT)		
				8	8				85	601.3655	WASHER	LN9025-0820K	
	8	8		8	8				84	601.3654	SCREW	LN9037-08018	
1	1	1		1					83	647.2112	UPPER U CHANNEL		
	8	8		8	8				82	601.3653	WASHER	93475A270	
	4	4		4	4				81	601.3652	LOCKNUT	93625A300	
	4	4		4	4				80	601.3651	SCREW	91292A080	
	1	1		1	1				79	647.1403	CUTTER ASSY (UPPER U CHANNEL)		
	5	5		5	5				78	601.3650	BOLT	AN3-15A	
REF	REF	REF	REF	REF	REF	REF	REF	REF	77	647.5701	GPS MOUNT KIT		
2		2	2		2	2		2	76	601.1954	SCREW	MS27039-1-17	
	2	2		2	2		2	2	75	647.2010	UPPER STRUT		
1	1	1	1	1	1	1	1	1	74	601.2045	RTV	LOCTITE 598	
1	1	1	1	1	1	1	1	1	73	600.1012	SEALANT	PR-1425 CLASS B	
1	1	1	1	1	1	1	1	1	72	600.0991	MAGNOBOND 6398 PART B		
1	1	1	1	1	1	1	1	1	71	600.0990	MAGNOBOND 6398 PART A		
4		4	4		4	4		4	70	601.3012	SCREW	MS27039-1-15	
2		2	2		2	2		2	69	601.3004	CAMLOC STUD		
2		2	2		2	2		2	68	601.3005	CAMLOC RETAINER		
2		2	2		2	2		2	67	601.3006	CAMLOC RECEPTACLE		
3 FT.		3 FT.	3 FT.		3 FT.	3 FT.		3 FT.	66	601.3011	P-SEAL		
1.1 FT.		1.1 FT.	1.1 FT.		1.1 FT.	1.1 FT.		1.1 FT.	65	601.3007	GROMMET	MS21266-2N	
2		2	2		2	2		2	64	601.3008	INSERT	NAS1834C3-300	
12		12	12		12	12		12	63	601.2364	RIVET	CR3213-4-8	
16		16	16		16	16		16	62	601.2468	RIVET	CR3213-4-7	
11		11	11		11	11		11	61	601.2991	RIVET	CR3213-4-6	
2		2	2		2	2		2	60	601.1039	RIVET	CR3213-4-2	
8		8	8		8	8		8	59	601.1183	RIVET	CR3213-4-5	
22		22	22		22	22		22	58	601.0790	RIVET	CR3213-4-3	
8		8	8		8	8		8	57	601.2995	RIVET	CR3213-6-6	
4		4	4		4	4		4	56	601.1915	RIVET	CR3213-4-4	
12		12	12		12	12		12	55	601.2207	NUTPLATE RIVET	CCR2645S-3-03	
4		4	4		4	4		4	54	601.1983	NUTPLATE RIVET	CCR2745S-3-03	
12		12	12		12	12		12	53	601.2980	NUTPLATE RIVET	CCR2645S-3-04	
12		12	12		12	12		12	52	600.0795	NUTPLATE	MS21047-3	
.1309	.1308	.1307	.1306	.1305	.1304	.1303	.1302	.1301	FIND #	PART #	DESCRIPTION	MATL	SPEC.

BOM Table (Restructured)

ORIGINAL DATE: 02/24/09
 MODIFIED: 02/24/09
 DRAWN BY: B. ROSANO
 CHECKED BY: D. BARKER
 DRAWING APPROVAL: P. BRADY
 CONTRACT NO.

UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE:
 3 PLACE DECIMALS ±.005
 ANGLES ±.3°

		3030 ENTERPRISE CT., SUITE A	
		VISTA, CA 92081 (760) 724-5300	
AFICAL INDUSTRIES INC. (DART AEROSPACE)		EC145 CABLE CUTTERS KIT	
SIZE: B	CAGE CODE: 07M76	DWG. NO: 647.1300	REV: E
SCALE: NONE		SHEET 3 OF 10	

1 2 3 4 5 6 7 8

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NOTES: UNLESS OTHERWISE SPECIFIED

1 AFTER INSTALLATION, APPLY F/N 73 A/R TO FILL GAPS AND FILLET EDGES

2. APPLY F/N 74 TO FAYING SURFACES

3 AT CUSTOMERS OPTION, INSTALL F/N 77 BY MATCH DRILLING ONTO F/N 1

4 INSTALL FOR 647.1301, 647.1302.

5 INSTALL FOR 647.1304, 647.1305.

6 APPLICABLE WHEN EUROCOPTER P/N 145-250014.11 IS INSTALLED WITH EUROCOPTER CABLE CUTTER FIXED PROVISIONS.

7 APPLICABLE WHEN REPLACING EUROCOPTER P/N 145-250074.11

8 INSTALL WITH:
647.1304
647.1305
647.1307
647.1308

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	LAST PROTOTYPE REVISION: PRO		N/C
A	INCORPORATED ECU 02948, 03020, 03048	06/05/09	P. BRAVO
B	INCORPORATED ECU 03919	01/25/11	P. BRAVO
C	INCORPORATED ECU 04269	07/05/13	P. BRAVO
D	INCORPORATED ECU'S 04485, 045921 & 04576	06/17/15	P. BRAVO
E	INCORPORATED ECU 05950	02/20/18	P. BRAVO

1		1	1		1	1		1	14	647.1817	SUPPORT, RH		
1		1	1		1	1		1	13	647.1912	BRACKET, LH		
1		1	1		1	1		1	12	647.1911	BRACKET, RH		
	8	8		8	8		8	8	11	647.0112	STRUT BRACKET		
							1	1	10	647.2110	LOWER RAIL		
							1	1	9	647.2111	UPPER RAIL		
	1	1		1	1		1	1	8	647.1610	WIPER DEFLECTOR, FWD		
	1	1		1	1		1	1	7	647.1601	WIPER DEFLECTOR ASSY, AFT		
							2	2	6	647.1701	SKID DEFLECTOR ASSY		
1		1	1		1	1		1	5	647.3201	GROUNDING CABLE ASSY		
1		1	1		1	1		1	4	647.2201	CROSS ASSY		
1		1	1		1	1		1	3	647.1602	DOUBLER ASSY		
	1	1		1	1		1	1	2	647.1402	CUTTER ASSY (LOWER)		
							1	1	1	647.1401	CUTTER ASSY (UPPER)		
X										647.1309	EC145 T2 FIXED PROVISIONS KIT		
	X									647.1308	EC145 T2 REMOVABLE PROVISIONS KIT		
		X								647.1307	EC145 T2 CABLE CUTTERS KIT		
			X							647.1306	FIXED PROVISIONS KIT U CHANNEL		
				X						647.1305	REMOVABLE PROVISIONS KIT U CHANNEL		
					X					647.1304	EC145 CABLE CUTTERS KIT U CHANNEL COMPATIBLE		
						X				647.1303	FIXED PROVISIONS KIT		
							X			647.1302	REMOVABLE PROVISIONS KIT		
								X		647.1301	EC145 CABLE CUTTERS KIT		
.1309	.1308	.1307	.1306	.1305	.1304	.1303	.1302	.1301	FIND #	PART #	DESCRIPTION	MATL	SPEC.

BOM Table(Restructured)

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE (MO-DA-YR) 07/04/09 DRAWN BY: E. BARKER P. BARKER DRAWING APPROVAL P. BRAVO 08/05/09 CONTRACT NO.	3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760) 724-5300 APICAL INDUSTRIES, INC. dba DART AEROSPACE
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.005 ANGLES ± .5°	EC145 CABLE CUTTERS KIT
		SHEET 1 OF 10	

1 2 3 4 5 6 7 8

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	4	4		4	4		4	4	51	601.3209	LOCKNUT	MS21042L4	
1	4	5	1	4	5	1	8	9	50	601.2973	LOCKNUT	MS21042-08	
27	19	46	27	19	46	27	18	45	49	601.2943	LOCKNUT	MS21042-3	
	3	3		3	3		3	3	48	601.2375	WASHER		
2	8	10	2	8	10	2	16	18	47	601.2764	WASHER	NAS1149FN832P	
62	42	104	62	42	104	62	40	102	46	601.1607	WASHER	NAS1149F0332P	
1		1	1		1	1		1	45	601.2525	SCREW	MS27039-0807	
4		4	4		4	4		4	44	601.1952	SCREW	MS27039-1-20	
							4	4	43	601.3010	SCREW	MS27039-0810	
	4	4		4	4		4	4	42	601.2988	SCREW	MS27039-0813	
6		6	6		6	6		6	41	601.1365	SCREW	MS27039-1-10	
3		3	3		3	3		3	40	601.2198	SCREW	MS27039-1-07	
	3	3		3	3		3	3	39	601.2999	SCREW		
18		18	18		18	18		18	38	601.2459	SCREW	MS27039C1-06	
	4	4		4	4		4	4	37	601.1622	SCREW	MS27039-1-14	
10		10	10		10	10		10	36	601.2051	SCREW	MS24694C52	
2		2	2		2	2		2	35	601.2823	BOLT	AN3-4A	
1		1	1		1	1		1	34	601.1324	BOLT	AN4CH6A	
	2	2		2	2		2	2	33	601.1874	BOLT	AN3C10A	
	12	12		12	12		16	16	32	601.2826	BOLT	AN3-11A	
	8	8		8	8		8	8	31	601.2638	WASHER	NAS1149F0432P	
	4	4		4	4		4	4	30	601.3002	BOLT	NAS6604-66	
2		2	2		2	2		2	29	647.1811	SPACER		
4		4	4		4	4		4	28	647.2511	NUT		
4		4	4		4	4		4	27	647.2510	SLEEVE		
13		13	13		13	13		13	26	647.1812	SHIM		
4		4	4		4	4		4	25	647.1910	CLIP		
1		1	1		1	1		1	24	647.1810	NOSE DOOR DOUBLER		
1		1	1		1	1		1	23	647.1818	NOSE DOOR SPACER		
2		2	2		2	2		2	22	647.1813	ANGLE		
1		1	1		1	1		1	21	647.1913	TEE		
1		1	1		1	1		1	20	647.1814	GUSSET, LH		
1		1	1		1	1		1	19	647.1815	GUSSET, RH		
1		1	1		1	1		1	18	647.1915	SUPPORT ANGLE		
	2	2		2	2		2	2	17	647.2011	LOWER STRUT		
1		1	1		1	1		1	16	647.1914	BRACKET		
1		1	1		1	1		1	15	647.1816	SUPPORT, LH		
.1309	.1308	.1307	.1306	.1305	.1304	.1303	.1302	.1301	FIND #	PART #	DESCRIPTION	MATL	SPEC.

BOM Table (Restructured)

ORIGINAL DATE 07/06/09
DRAWN BY J. KOSIOWSKI
CHECKED J. BARKER
DRAWING APPROVAL P. BRAVO 08/05/09
CONTRACT NO.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.03
3 PLACE DECIMALS ±.010
ANGLES ±.2°

DART AEROSPACE
3030 ENTERPRISE CT., SUITE A
VISTA, CA. 92081
(760)-724-5300
AFRICAL INDUSTRIES, INC.
(dba DART AEROSPACE)
EC145 CABLE CUTTERS KIT
SIZE B CAGE CODE 07M16 DWG. NO. 647.1300 REV. E
SCALE NONE SHEET 2 OF 10